

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5445-041	LONGITUDINAL BEAM ASSEMBLY, LH
1	2	D5445-043	END CAP ASSEMBLY
2	4	D5445-5	SPACER
3	8	CR2672-3-(03)	RIVET CHERRY, CSK
4	1	D5445-1	LONGITUDINAL BEAM, LH
5	3	MS21059-4	NUT PLATE
6	1	MS21061L4	NUT PLATE
7	4	MS24694-S3	SCREW, CSK 100°
8	A/R	SIKAFLEX-241/-291	SEALANT

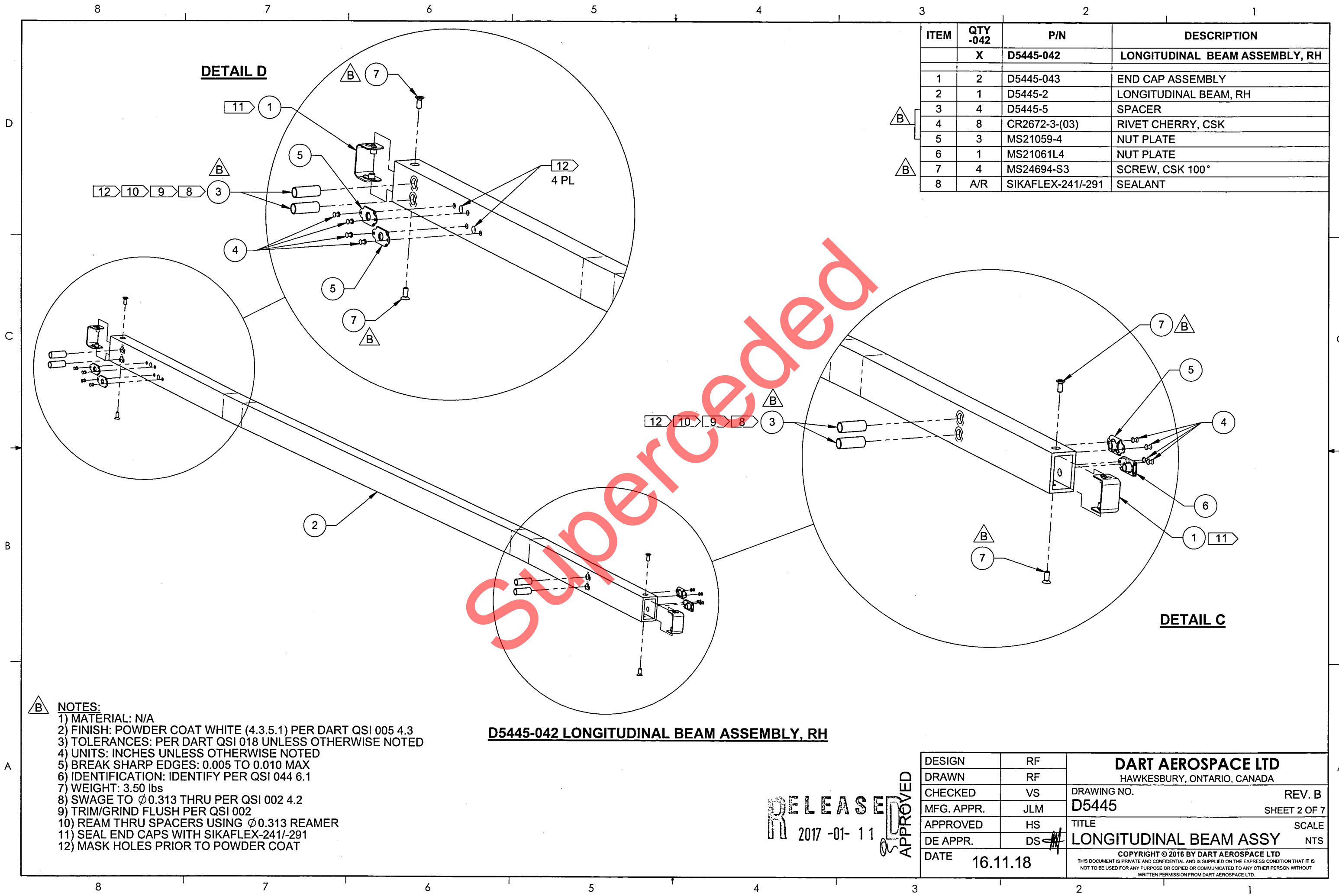
D5445-041 LONGITUDINAL BEAM ASSEMBLY, LH

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
  - 7) WEIGHT: 3.50 lbs
  - 8) SWAGE TO  $\phi 0.313$  THRU PER QSI 002 4.2
  - 9) TRIM/GRIND FLUSH PER QSI 002
  - 10) REAM THRU SPACERS USING  $\phi 0.313$  REAMER
  - 11) SEAL END CAPS WITH SIKAFLEX-241/-291
  - 12) MASK HOLES PRIOR TO POWDER COAT

RELEASED  
2017-01-11  
17-52

APPROVED

B	REDESIGN -1/-2/-041/-042 (ZN A4-1, A4-2, B4-4, B4-5); ADDED -5 (ZN B4-7), REVISE BOM & NOTES (ZN A8-1, A8-2, D3-1, D3-2)	RF	16.11.18
A	NEW ISSUE	RF	16.05.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5445	SHEET 1 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LONGITUDINAL BEAM ASSY	NTS
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ITEM	QTY -042	P/N	DESCRIPTION
	X	D5445-042	LONGITUDINAL BEAM ASSEMBLY, RH
1	2	D5445-043	END CAP ASSEMBLY
2	1	D5445-2	LONGITUDINAL BEAM, RH
3	4	D5445-5	SPACER
4	8	CR2672-3-(03)	RIVET CHERRY, CSK
5	3	MS21059-4	NUT PLATE
6	1	MS21061L4	NUT PLATE
7	4	MS24694-S3	SCREW, CSK 100°
8	A/R	SIKAFLEX-241/-291	SEALANT

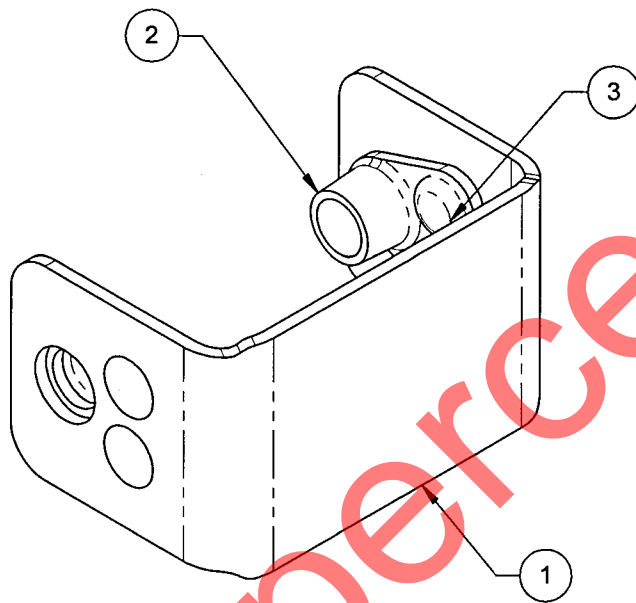
- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
  - 7) WEIGHT: 3.50 lbs
  - 8) SWAGE TO  $\phi 0.313$  THRU PER QSI 002 4.2
  - 9) TRIM/GRIND FLUSH PER QSI 002
  - 10) REAM THRU SPACERS USING  $\phi 0.313$  REAMER
  - 11) SEAL END CAPS WITH SIKAFLEX-241/-291
  - 12) MASK HOLES PRIOR TO POWDER COAT

**D5445-042 LONGITUDINAL BEAM ASSEMBLY, RH**

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CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	<b>D5445</b>	SHEET 2 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>LONGITUDINAL BEAM ASSY</b>	NTS
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ITEM	QTY -043	P/N	DESCRIPTION
	X	D5445-043	END CAP ASSEMBLY
1	1	D5445-3	END CAP
2	2	MS21086L08	ANCHOR NUT
3	4	MS20426AD3-(4)	RIVET, SOLID, CSK



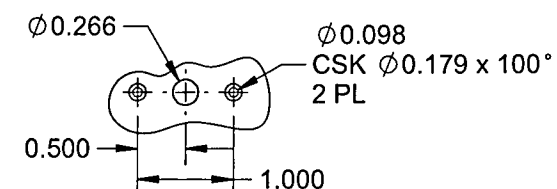
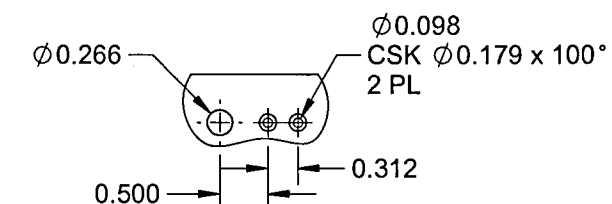
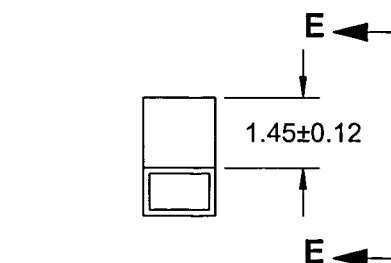
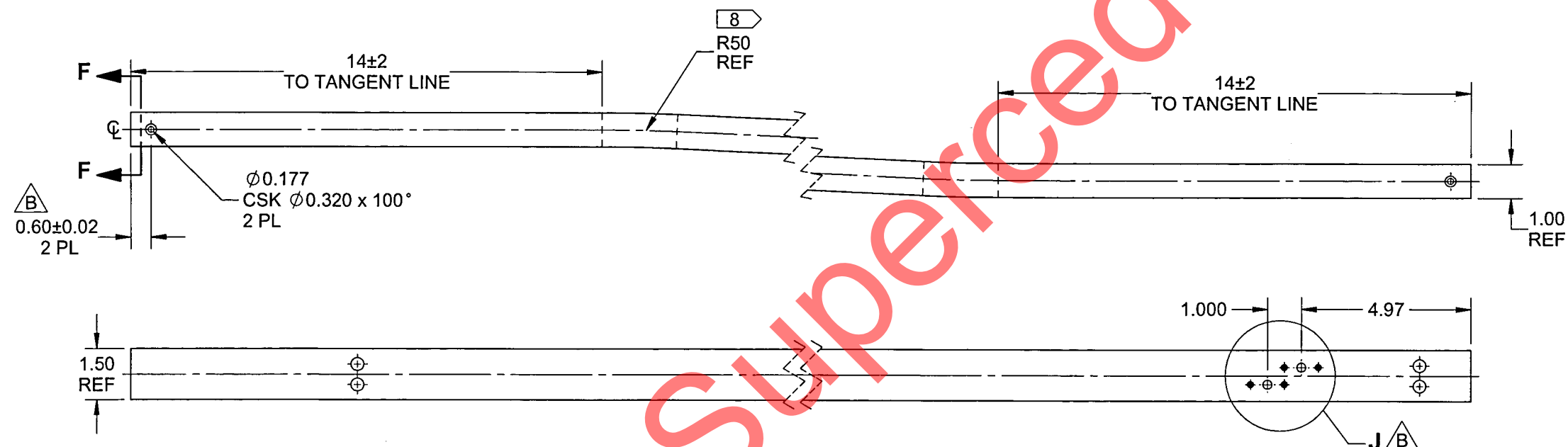
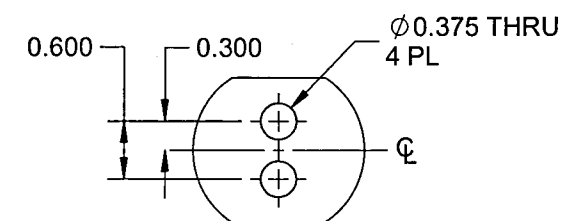
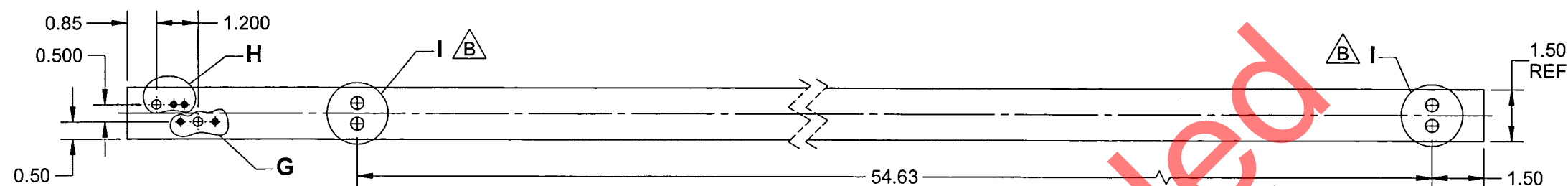
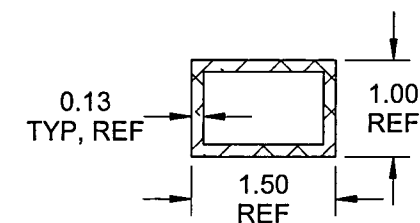
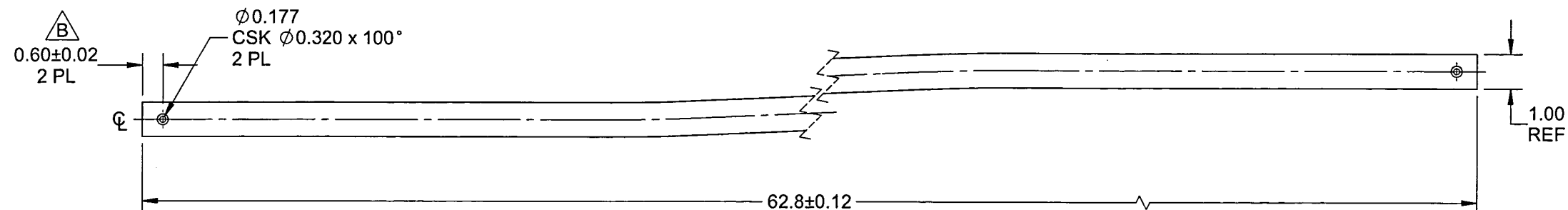
**D5445-043 END CAP ASSEMBLY**

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
  - 7) WEIGHT: 0.01 lbs

RELEASED  
2017-01-11

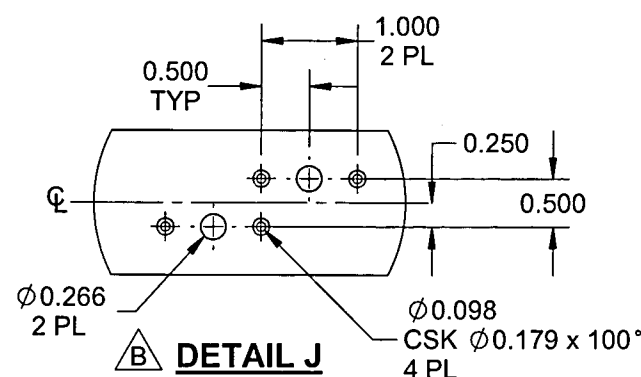
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DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5445	SHEET 3 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LONGITUDINAL BEAM ASSY	NTS
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# D5445-1 LONGITUDINAL BEAM, LH

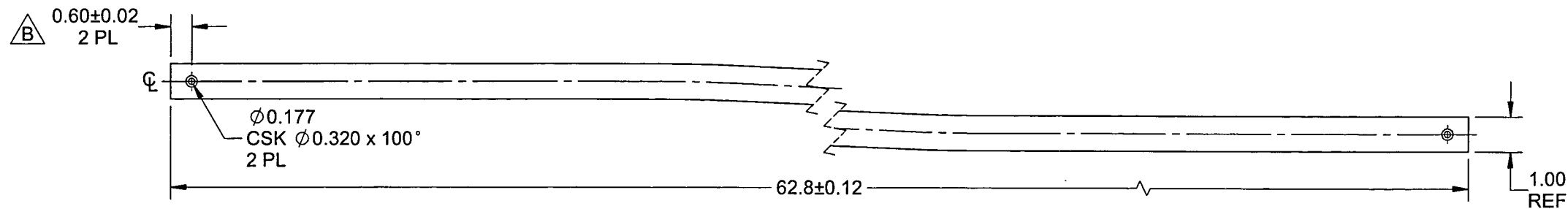
- NOTES:
- 1) MATERIAL: POSSIBLE VENDOR McMASTER CARR, P/N 6546K38, 6ft IN LENGTH  
6061-T6 RECTANGULAR TUBE 1.5" x 1.0" x 0.125" WALL  
PER ASTM B221, YIELD STRENGTH: 35,000 psi
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 3.43 lbs
  - 8) BEND RADIUS NOT CRITICAL



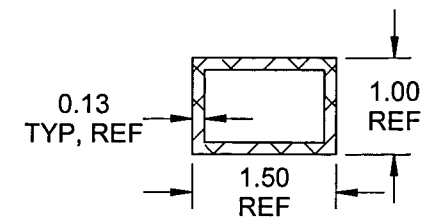
RELEASED  
2017-01-11

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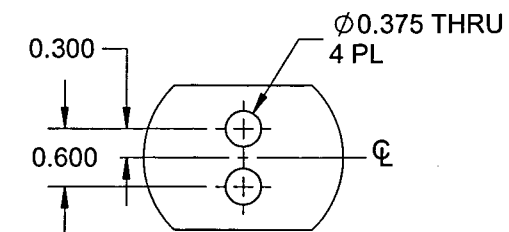
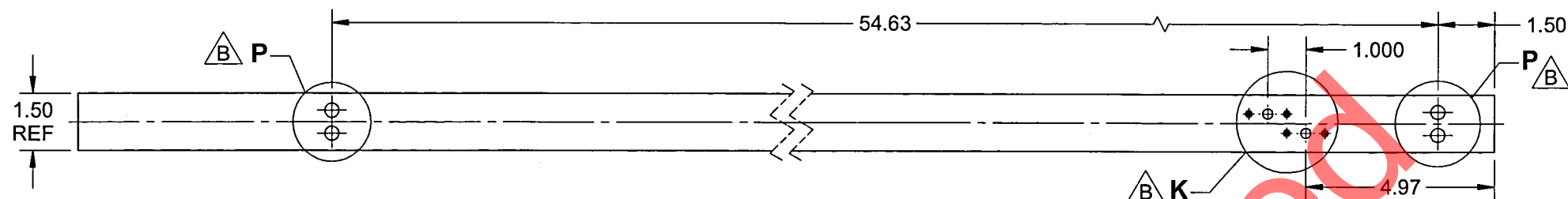
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5445	SHEET 4 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LONGITUDINAL BEAM ASSY	NTS
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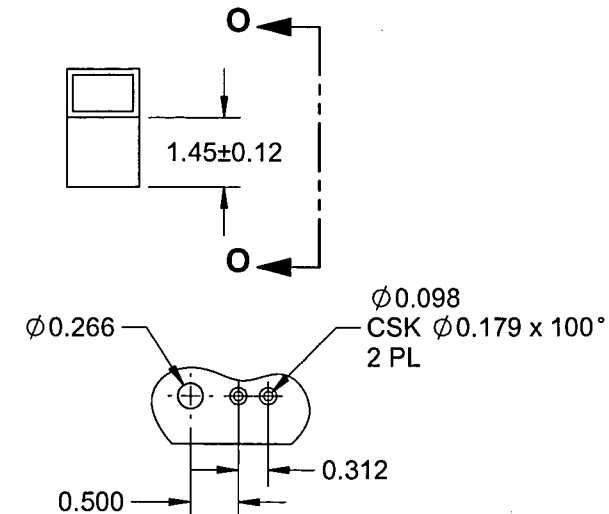
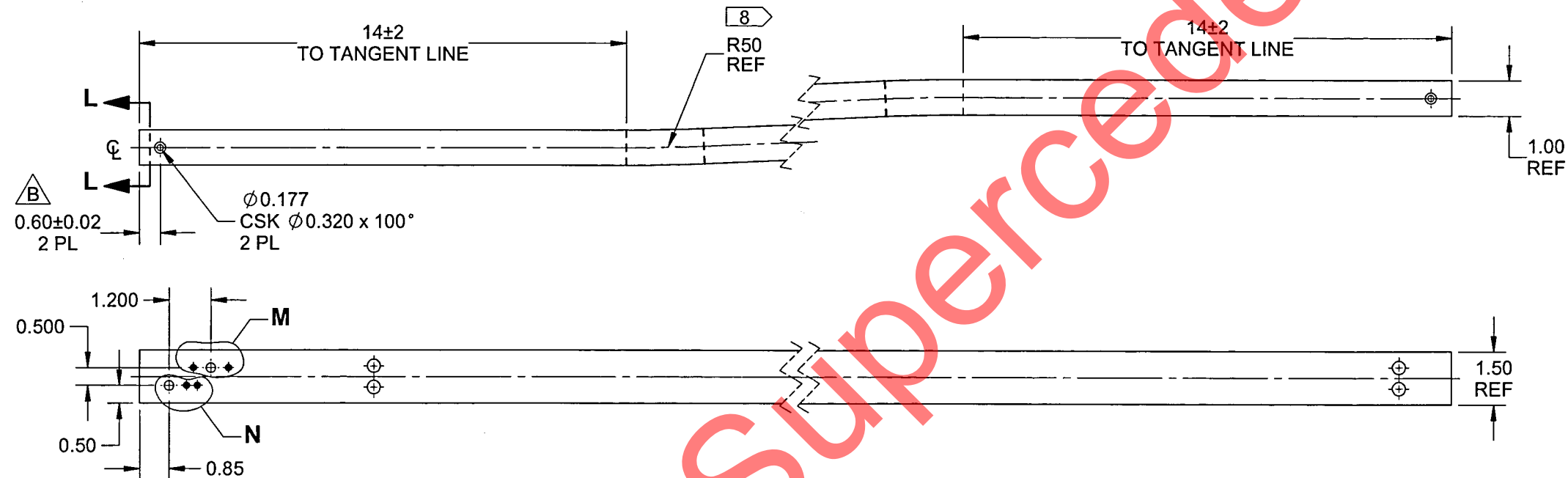
VIEW O-O



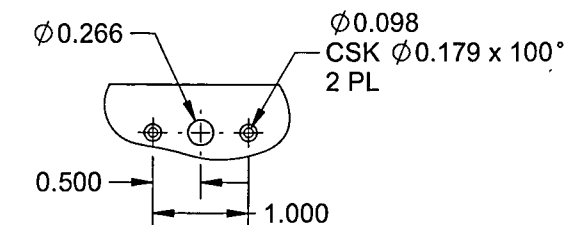
SECTION L-L



DETAIL P

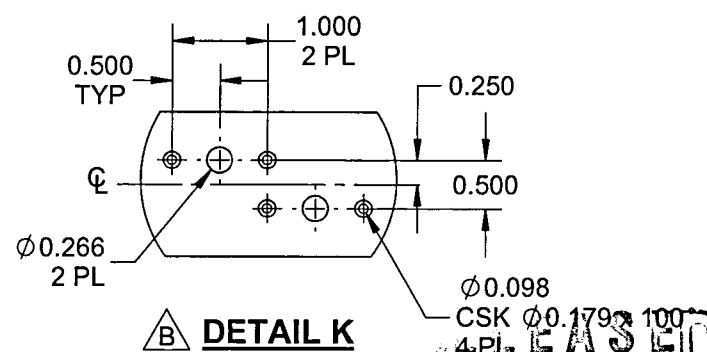


DETAIL N



DETAIL M

D5445-2 LONGITUDINAL BEAM, RH



DETAIL K

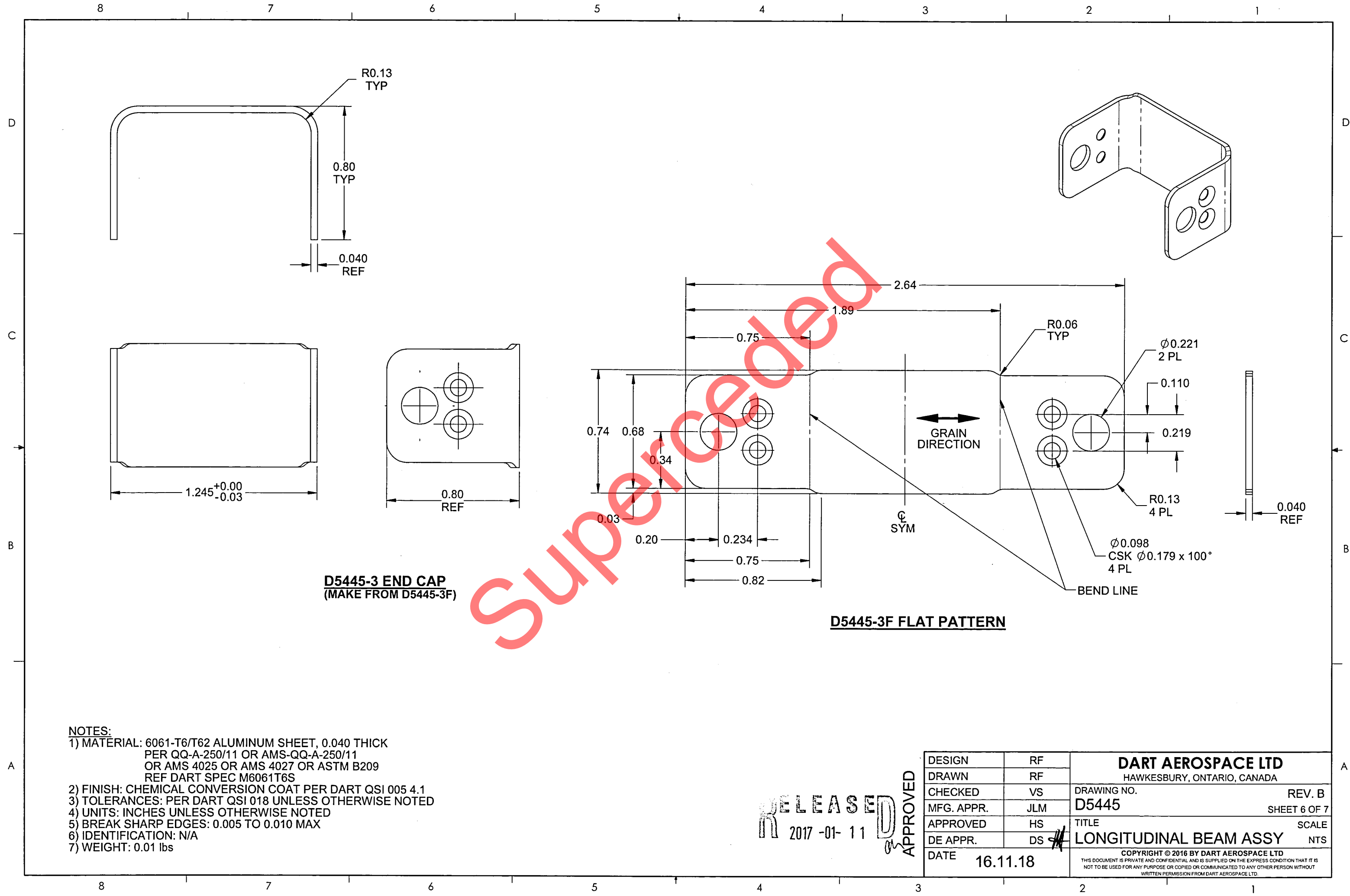
NOTES:

- 1) MATERIAL: POSSIBLE VENDOR McMASTER CARR, P/N 6546K38, 6ft IN LENGTH  
6061-T6 RECTANGULAR TUBE 1.5" x 1.0" x 0.125" WALL  
PER ASTM B221, YIELD STRENGTH: 35,000 psi
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.43 lbs
- 8) BEND RADIUS NOT CRITICAL

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5445	SHEET 5 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LONGITUDINAL BEAM ASSY	NTS
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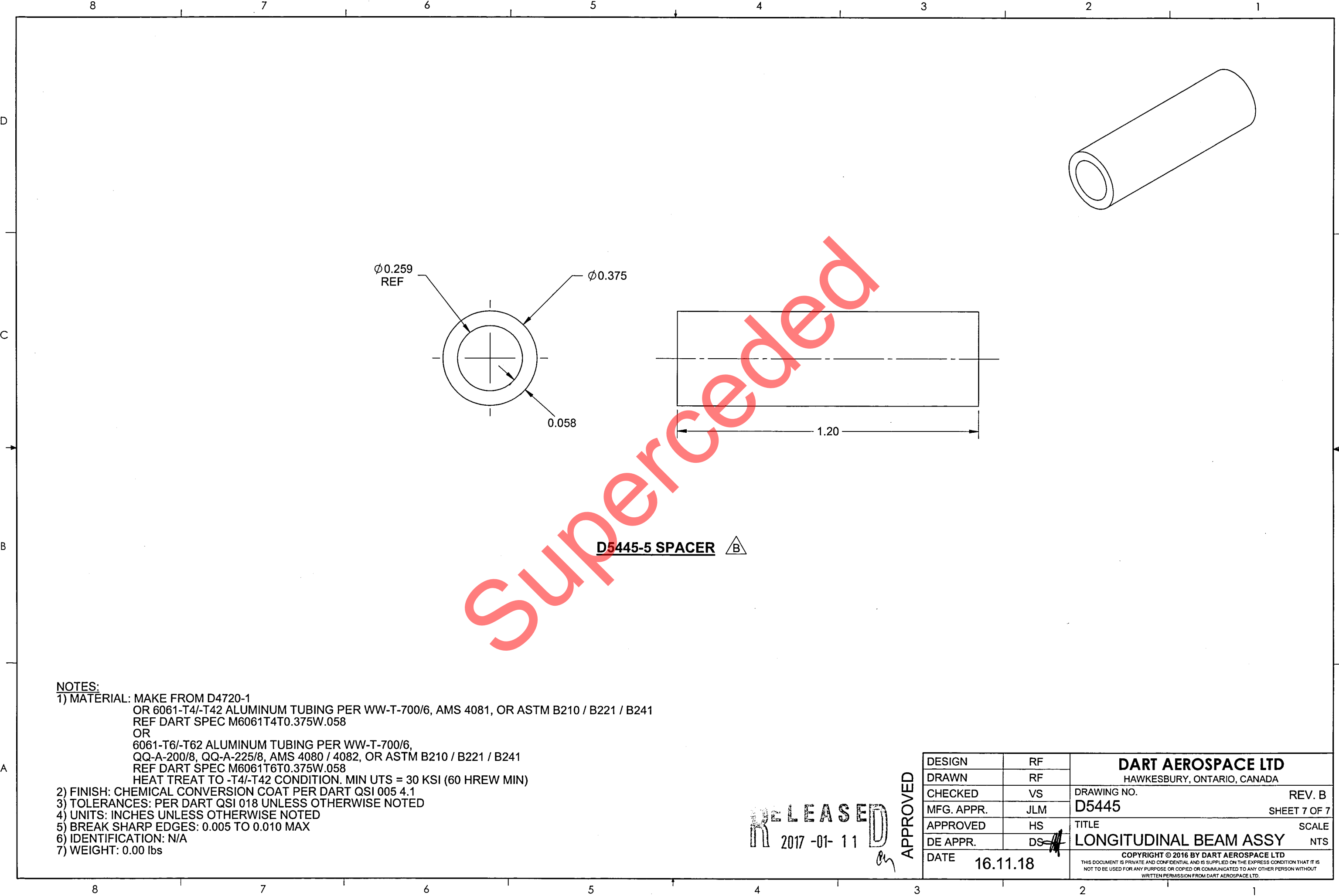
D5445-3 END CAP  
(MAKE FROM D5445-3F)

D5445-3F FLAT PATTERN

- NOTES:
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.01 lbs

RELEASED  
2017-01-11  
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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5445	SHEET 6 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LONGITUDINAL BEAM ASSY	NTS
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NOTES:

- 1) MATERIAL: MAKE FROM D4720-1  
OR 6061-T4/-T42 ALUMINUM TUBING PER WW-T-700/6, AMS 4081, OR ASTM B210 / B221 / B241  
REF DART SPEC M6061T4T0.375W.058  
OR  
6061-T6/-T62 ALUMINUM TUBING PER WW-T-700/6,  
QQ-A-200/8, QQ-A-225/8, AMS 4080 / 4082, OR ASTM B210 / B221 / B241  
REF DART SPEC M6061T6T0.375W.058  
HEAT TREAT TO -T4/-T42 CONDITION. MIN UTS = 30 KSI (60 HREW MIN)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

RELEASED  
2017 -01- 11

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5445	SHEET 7 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LONGITUDINAL BEAM ASSY	NTS
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